

Date: Wednesday, 1/4/2006 2:36:23 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L UTILITY BASKET
Job Number : 25389	
Estimate Number : 11272	
P.O. Number : N/A	Part Number : D206540011
This Issue : 1/4/2006 S.O. No. : N/A	Drawing Number : UNDER REVIEW D206-540 Rev. I
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : N/A
Previous Run : 23136	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/30/2006 Qty: 1 Um: Each
Checked & Approved By : SEE ABOVE USER & DATE	
Comment : Est Rev:1 Revised per Rev I 05-12-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-540-011 CHG004

DA 06/02/06

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

3.0	25389A	206L BASKET BASE
-----	--------	------------------



Comment: Sub-Component 206L BASKET BASE

4.0	25389B	206L BASKET LID
-----	--------	-----------------



Comment: Sub-Component 206L BASKET LID

5.0	D2332041	Lid Prop Assembly 6.69"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y B25136 (1)

6.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER B23396 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L UTILITY BASKET

Job Number: 25389

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment

B25825

(1)

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535

Spring

B24532

(2)

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537

Bushing

B24877

(2)

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4. D2931

Bumper

B21139

(4)

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet

M13767

(4)

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A

Bolt

M18369

(2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206L UTILITY BASKET

Job Number: 25389

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-24A

Bolt M17204 : ①

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt M19413 : ②

15.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt M18822 : ③

16.0

AN517A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

6 AN5-17A

Bolt M19551 : ④

17.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD416

Washer M19085 : ⑤

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer M18254 : ⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25389

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Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer

M18918

(4)

20.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD8

Washer

M11729

(4)

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3)

M18917

(2)

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

M17997

(4)

23.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

M19075

(4)

580 06503.16

(1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-540

SAD 06-03-16

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

27.0

D2249041

Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 d2249-041 bracket

B22498

28.0

D2258170

Placard - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2858-170 PLACARD

B16266

SAD 06-03-16

29.0

D2259

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 ~~D2259~~ D2259 Placard

B10671

30.0

D2525

Spacer Kit



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit

B12105

2 Label D2728-3

B22553

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-16	24	D2858-170 placard goes onto basket once ASSY is complete. ADD sticker to ASSY pick list. B# 02728-3 permanent change	EC	SAD 05:03:16		06-03-16	06-03-16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/03/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		D2858-170 Pl						

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Drawing Name: 206L UTILITY BASKET

Job Number: 25389

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

D2526

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2526

Bushing

B 17519

②

32.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2537

BUSHING

B 24877

②

33.0

D2748

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2748

Clevis

B 15196

②

34.0

D27495

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-5

Strut

B 15232

①

35.0

D27497

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-7

Strut

B 10983

①

36.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A

Bolt

06.03.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25389

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A Bolt

m100089 (8)

38.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12A Bolt

m18822 (2)

39.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

m2951 (2)

40.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A Bolt

1x m16273 / 1x m19551 (2)

41.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer m19085

(12)

42.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516 Washer

m18254 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ - Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 25389

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 MS21042L4 Nut (or -4) m19099 (4)

44.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5

Nut

m19073 (2)

45.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-011

Location:

PPP Rev: G

47.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



(1)
06/03/23
u 06-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-540	REV. 1 SHEET 1 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS
C	94.07.28	REVISED DRAWING	
D	94.11.12	ADDED D2323 STRUT	
E	94.11.12	CHANGED SECTION C-C	
F	94.11.12	ADDED HANDLE AND LID PROP	
G	99.09.21	REDRAW, CHANGE LATCH/HINGE/STRUTS	
H	99.12.02	INCORPORATE DSI 9174 / DEO 9167	
I	05.11.10	REPLACED PIANO HINGE SYSTEM	

Qty -011	Qty -013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
	1	D2012-107	CLEVIS
2	6	D2022-101	SPACER
2	2	D2249-041	BRACKET
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	D2258-170	PLACARD
1	1	D2259	PLACARD*
	1	D2330-041	BASKET ASSEMBLY
	1	D2330-043	LID ASSEMBLY
1	1	D2332-041	LID PROP ASSEMBLY
2	2	D2525	SPACER KIT
2	2	D2526	BUSHING
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2	D2748	CLEVIS
	1	D2749-1	STRUT
	1	D2749-3	STRUT
1		D2749-5	STRUT
1		D2749-7	STRUT
	2	D2814	STRUT
4	4	D2931	BUMPER
2	2	AN3-16A	BOLT
	3	AN320-4	NUT
	3	AN380-2-2	COTTER PIN
	2	AN4-12	BOLT
2	2	AN4-12A	BOLT
2	2	AN4-21A	BOLT
1	1	AN4-22A	BOLT
1	1	AN4-24A	BOLT
8	8	AN4-5A	BOLT
	1	AN4-8	BOLT
2	2	AN4-7A	BOLT
6	6	AN5-17A	BOLT
16	23	AN960JD416	WASHER
6	6	AN960JD516	WASHER
4	4	AN960JD8	WASHER
4	5	AN970-4	WASHER
4	4	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
8	8	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
	1	MS27038-4-11	SCREW

*NOTE: Placard D2259 to be installed in cock pit near the airspeed indicator.

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WITH

25389



DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D206-540	REV. 1 SHEET 2 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-540-011	70 lb	40.0 in	2800 in-lb	111.0 in	7770 in-lb
206 L Series Basket Installation	31.8 kg	1.0 m	31.8 m-k-g	2.8 m	89.0 m-k-g
D206-540-013	50 lb	40.0 in	2000 in-lb	99.0 in	4950 in-lb
206 A/B Series Basket Installation	22.7 kg	1.0 m	22.7 m-k-g	2.5 m	56.8 m-k-g

GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification. This basket can only be installed on the starboard side of the aircraft on high gear. Ensure that any steps that are outboard of the crosstubes are removed.

WORKMANSHIP

Unless otherwise stated, all workmanship should be to the standard set by the Aircraft Maintenance Manual.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Maintenance Manual Supplement MMS-D206-540.

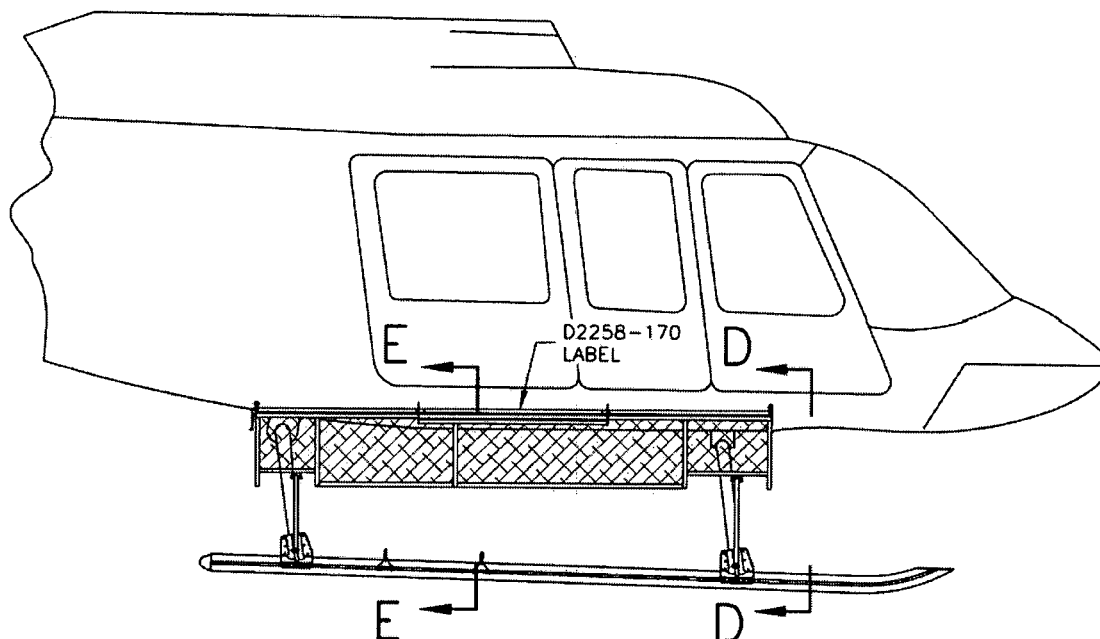
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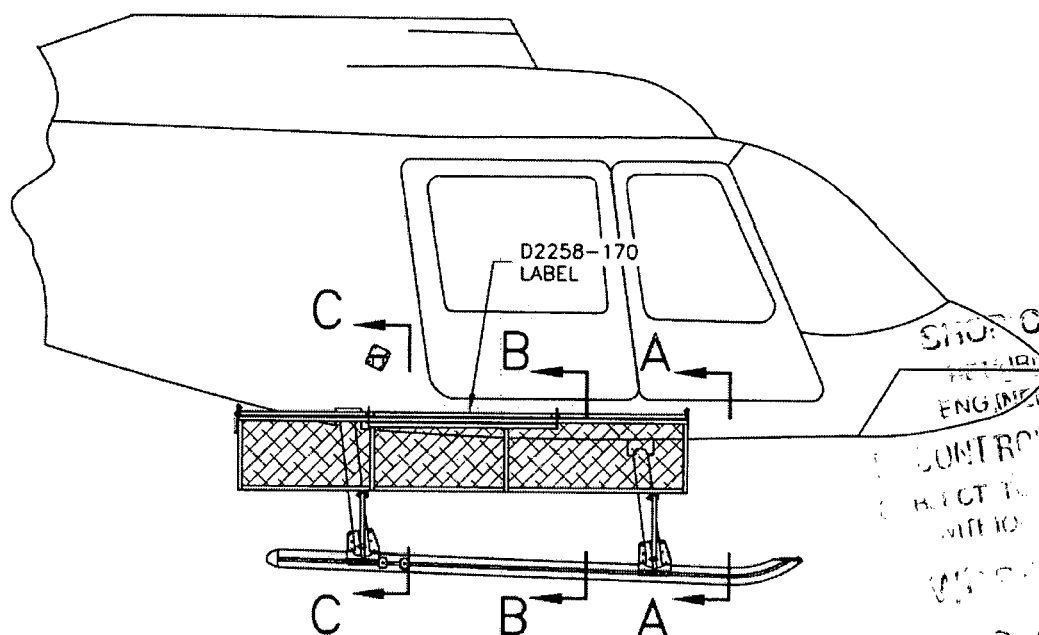
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DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



D206-540-011 206L/L1/L3/L4 BASKET INSTALLATION



D206-540-013 206A/B BASKET INSTALLATION

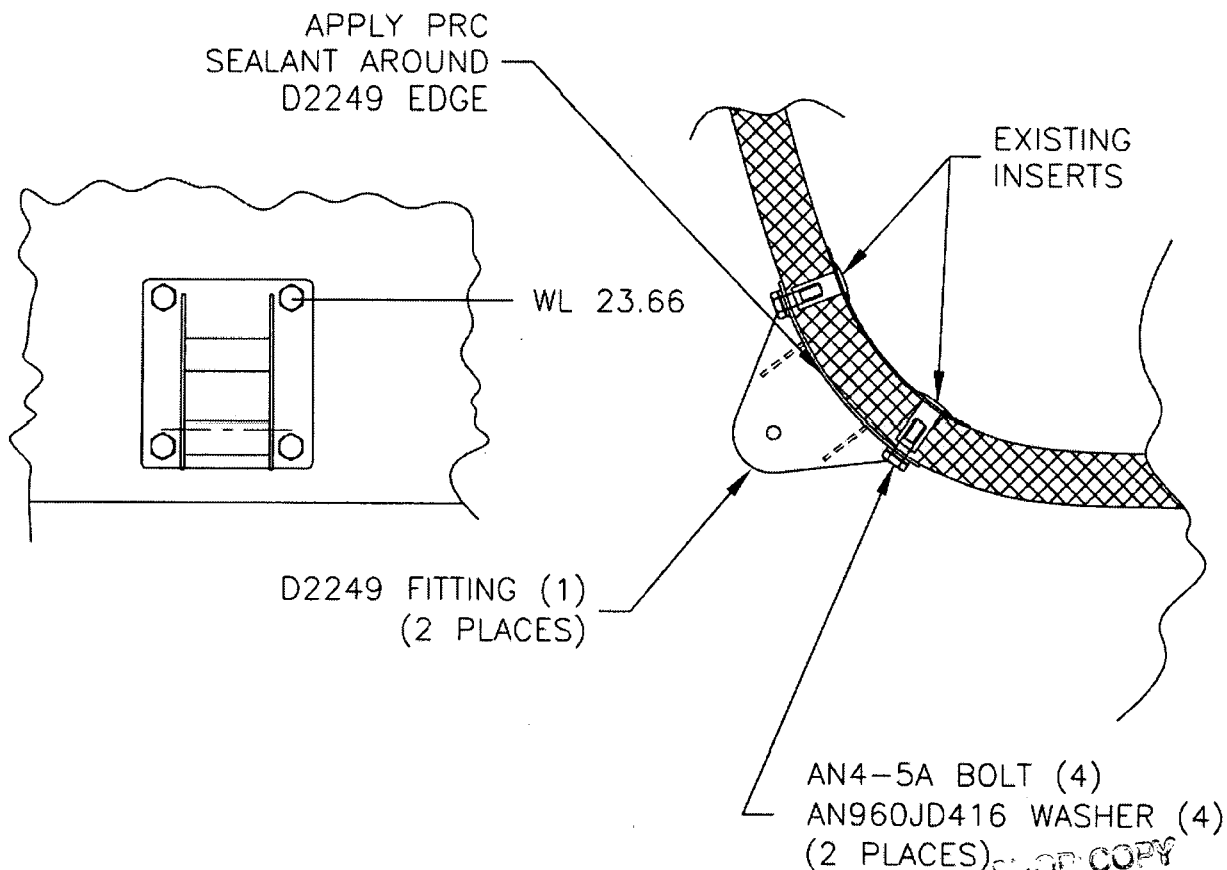
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DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



BRACKET DETAIL

REPLACE 206-031-370-6
AND 206-031-370-8 STEPS AS
REQUIRED WITH D2249 FITTINGS.
REFER TO SERVICE INSTRUCTION
BHT-206-SI-22

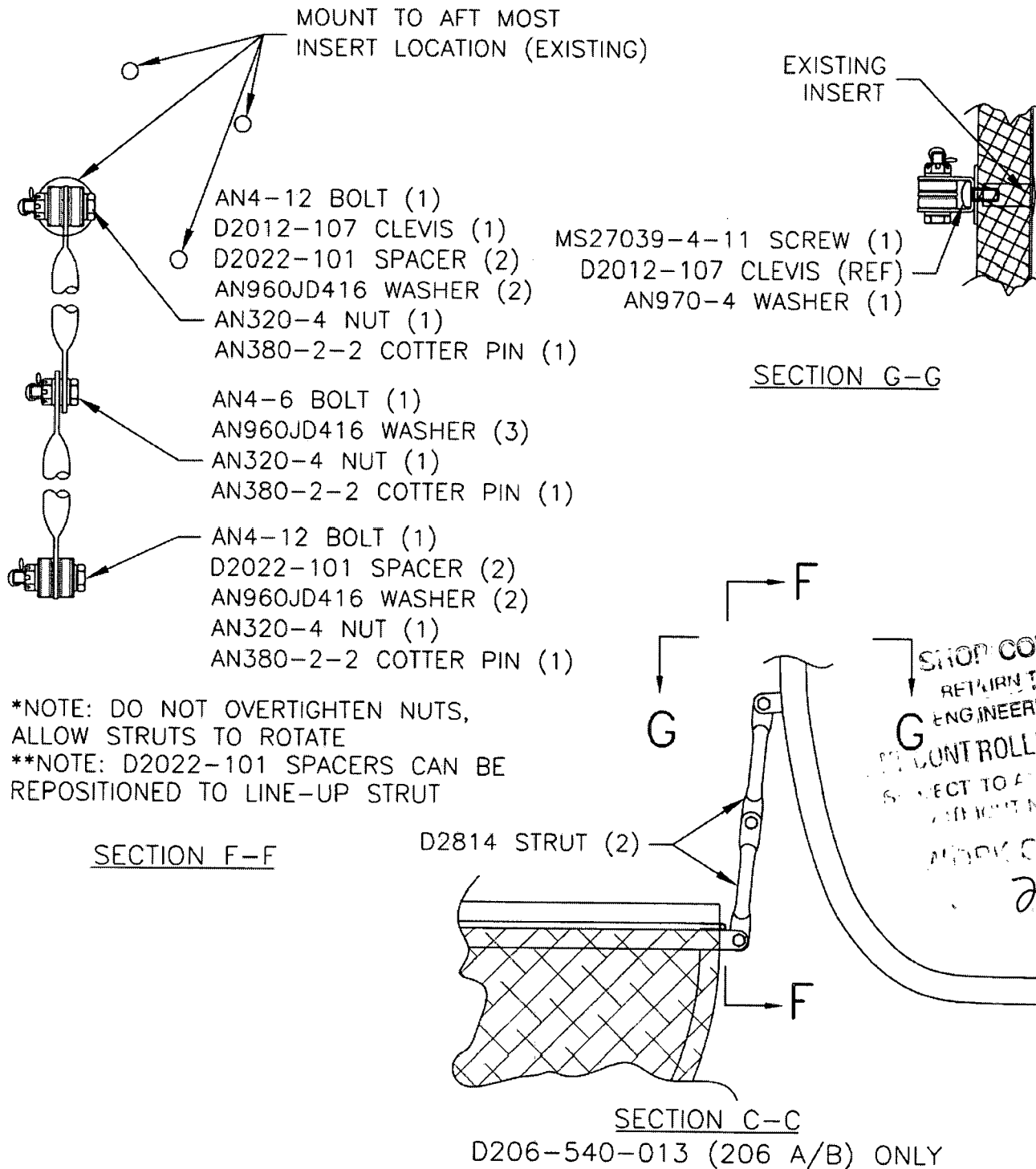
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CHECKED 	APPROVED 	DRAWING NO. D206-540	REV. 1 SHEET 5 OF 8
DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS

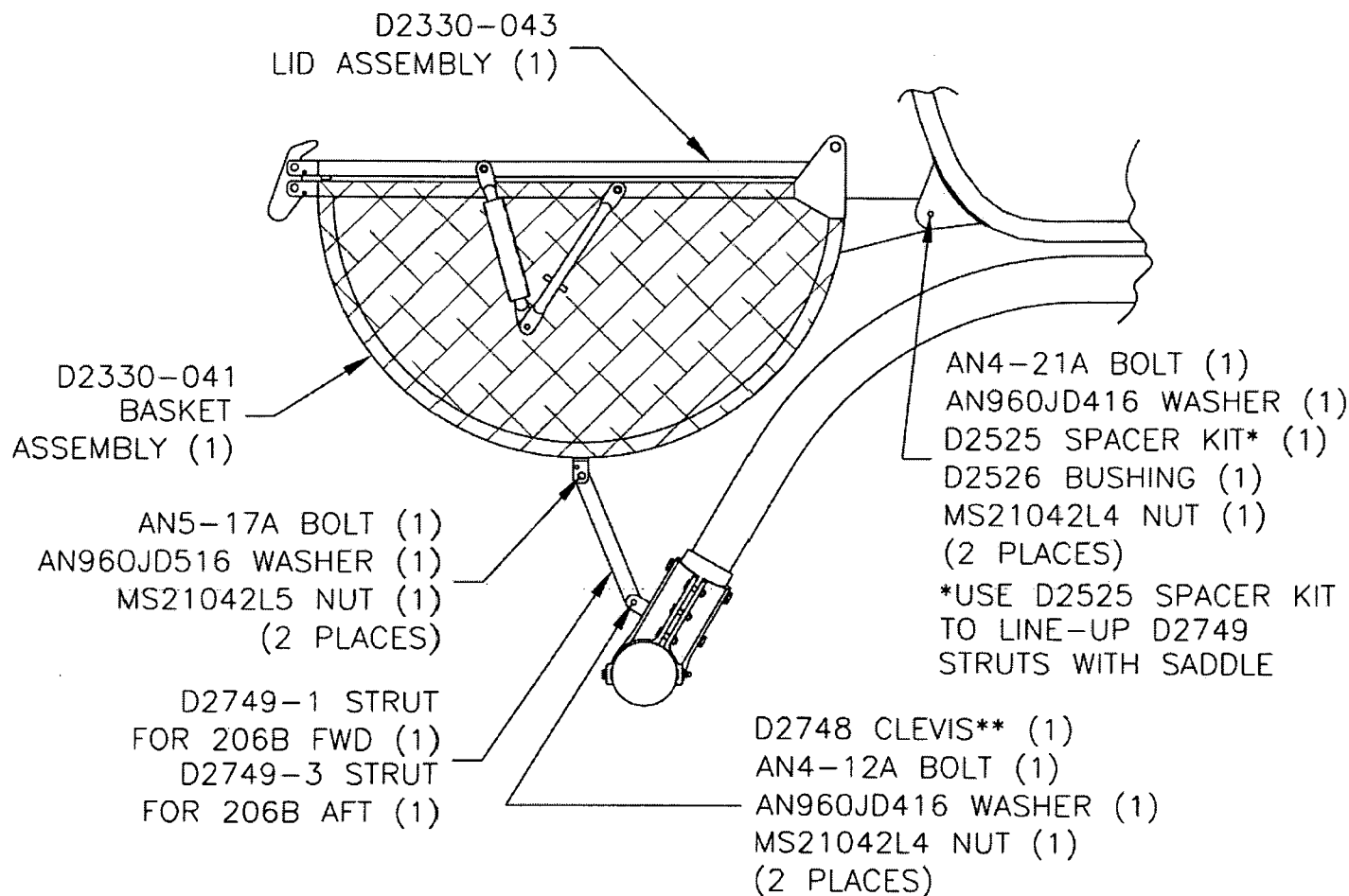


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		TITLE	UTILITY BASKET INSTALLATION	SHEET 6 OF 8
				SCALE
				NTS



**NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748
CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

SECTION A-A AND B-B

D206-540-013 (206 A/B) ONLY

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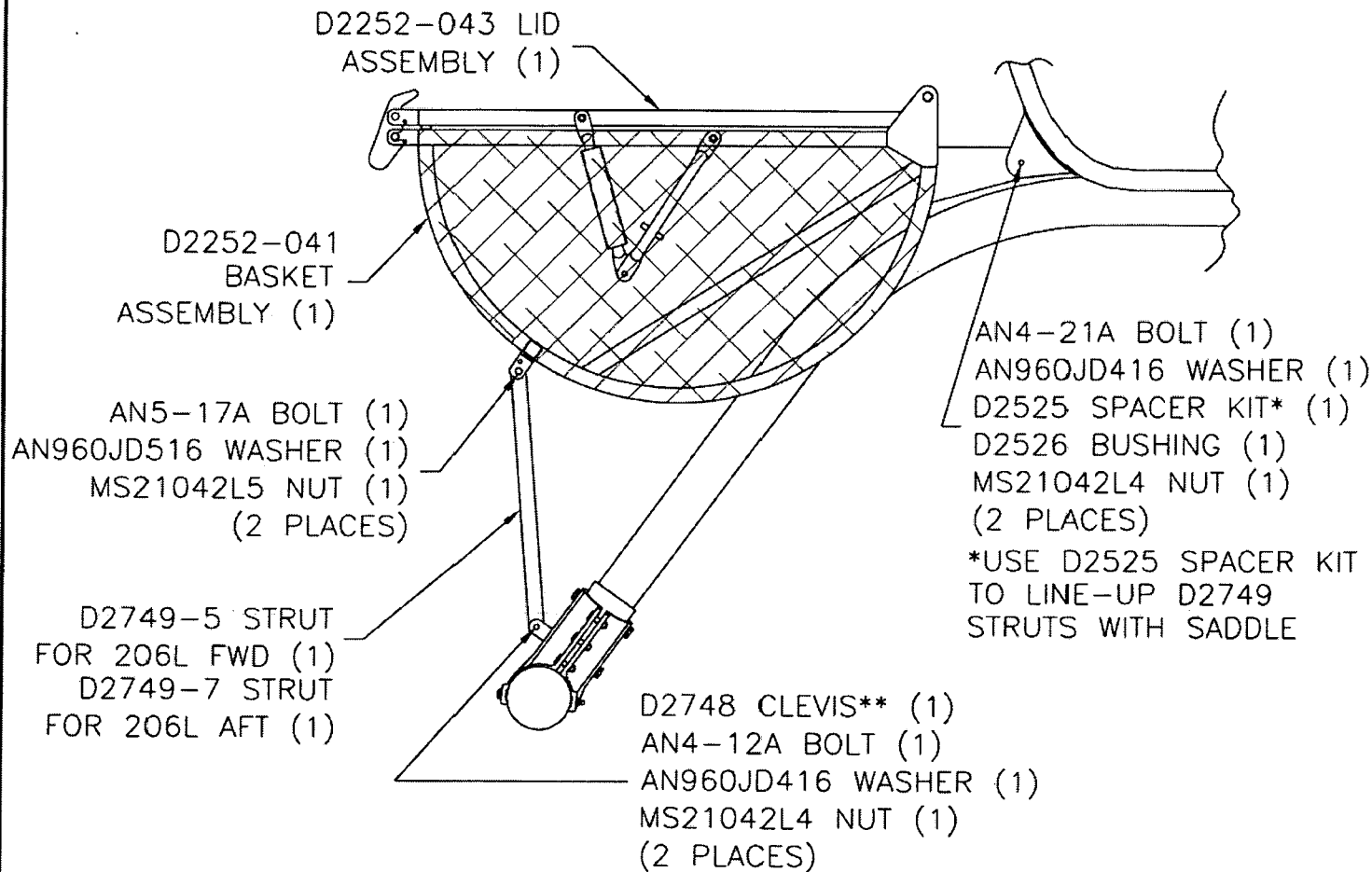
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DATE	TITLE		SCALE		
05.11.10	UTILITY BASKET INSTALLATION		NTS		



NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748 CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

SECTION D-D AND E-E

D206-540-011 (206 L/L1/L3/L4) ONLY

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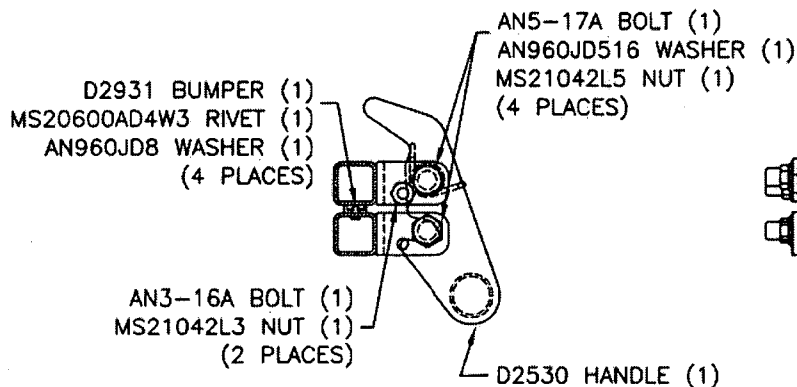
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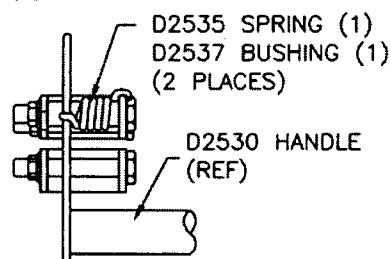
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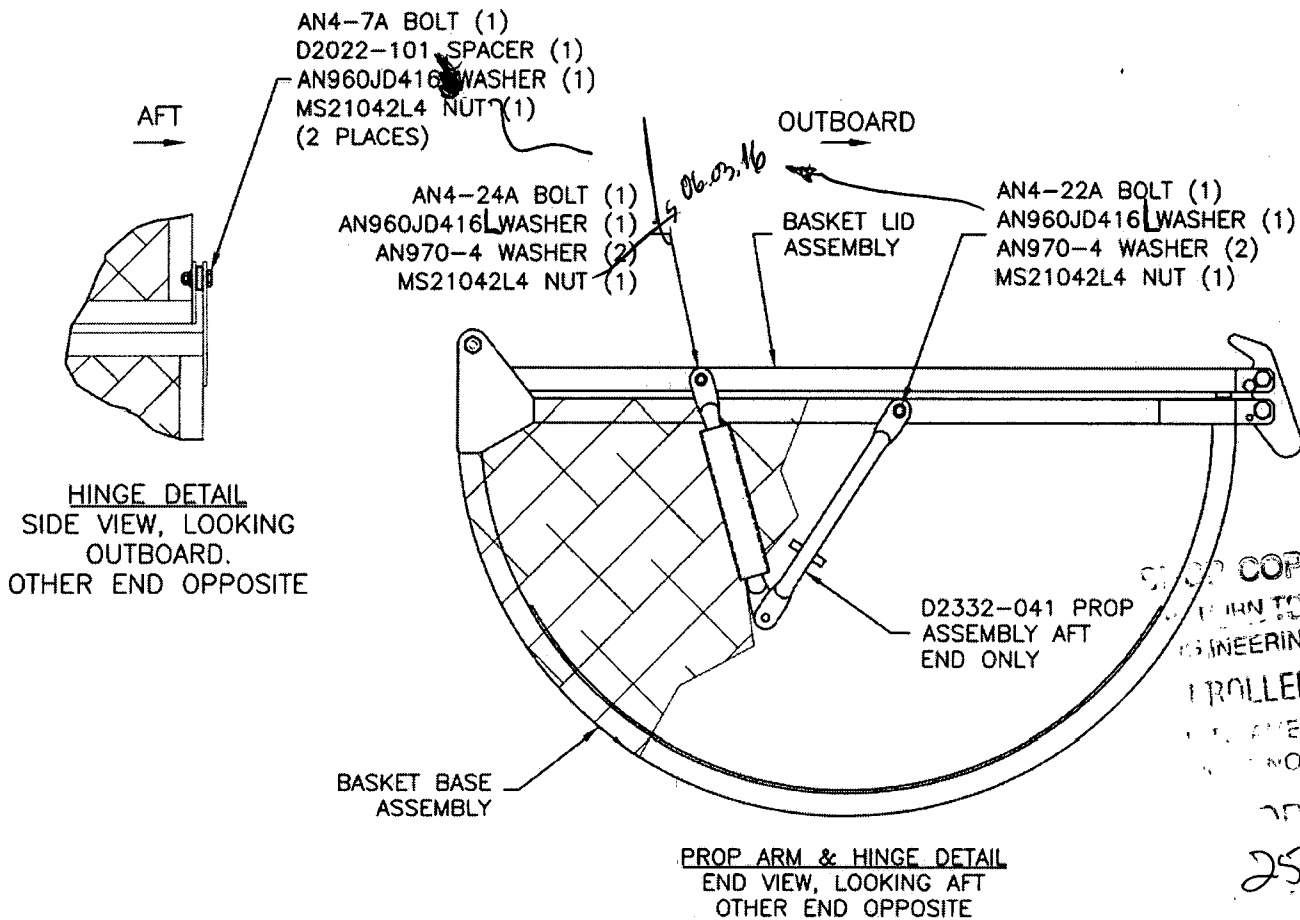
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DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



LATCH DETAIL



SPRING DETAIL



PROP ARM & HINGE DETAIL
END VIEW, LOOKING AFT
OTHER END OPPOSITE

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